

Work Order ID 85997

85997

Page 1

Item ID: D3204-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Release Pedal Assembly

Stop ***NS2***

Start Date: 19/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/19 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3204	Rev A1								
100	Large Fab	0.00							
100									
Large Fab									
Large Fab	Memo	0.00							
	1- Weld assembly as per Dwg D3204 using Jig D3204-041T1.								
	2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld.								
	3- Use JB weld compound to plug the hole after assembly. 4- Grind JB weld flush after it is cured.								
110	QC9- Inspect visual per QS1004- Fusion Welds	0.00							
110									
QC									
Quality Control	Memo	0.00							

4 R 13-1-17

4 B-01-07

DAS
18
2-82

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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June-19-12 12:02:20 PM

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

Smf
13-17

4

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

4

NA 13-17

Hand Finishing

140

Grey Sandtex(Ref:4.3 5.6) per QSI005 4.3

0.00

140

Powdercoat

M 122966

Memo

0.00

4

φ

16L 13-1-8.

Powder Coating

Cover holes for bushing

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:20
320°
9:50

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

160

Small Fab

0.00

160

Small Fab

Memo

0.00

Small Fab

Install D3204-7 bushing as shown in Dwg D3204

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

Handwritten signature and date 6/3/08

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Customer:

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location

G-A

0.00

180

Packaging

Memo

0.00

Packaging

*4x**13/01/10*

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

*13/1/10**MR**13-01-10*

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Picklist Print

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Page 1

Work Order ID: 85997

85997

Parent Item: D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: C05.08.11Added Step 25 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3204-1		Manufactured	No			100	Each	4.0000	1	4			

D3204-1

Tube

**

EL 13-1-3

85783 x 4

Location

Loc Qty

Loc Code

WA021

4

79294

4

D3204-11

Manufactured No

100

Each

8.0000

1

4

D3204-11

Plate

**

EL 13-1-3

86778 x 4

Location

Loc Qty

Loc Code

WA021

8

57522

8

D3204-13

Manufactured No

100

Each

14.0000

2

8

D3204-13

Gusset

**

EL 13-1-3

85984 x 3

88177 x 5

Location

Loc Qty

Loc Code

WA021

14

70315

3

73465

11

D3204-3

Manufactured No

100

Each

13.0000

1

4

D3204-3

Arm

**

EL 13-1-3

Location

Loc Qty

Loc Code

WA019

13

79801

13

86709 x 4

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D3204-041

D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 4.00

Required Qty: 4.00

D3204-5 Manufactured No

100 Each 4.0000 1 4

D3204-5

**

EL 13-1-3

Arm

86702 x 4

Location

Loc Qty

Loc Code

WA021

4

79292

4

D3204-9 Manufactured No

100 Each 7.0000 1 4

D3204-9

**

EL 13-1-3

Pedal

85980 x 3

Location

Loc Qty

Loc Code

WA020

7

87104 x 1

79803

7

D3204-7 Manufactured No

160 Each 7.0000 2 8

D3204-7

**

EL 13/01/08

Bushing

Location

Loc Qty

Loc Code

GA

7

77091

1

79802

6

B85981

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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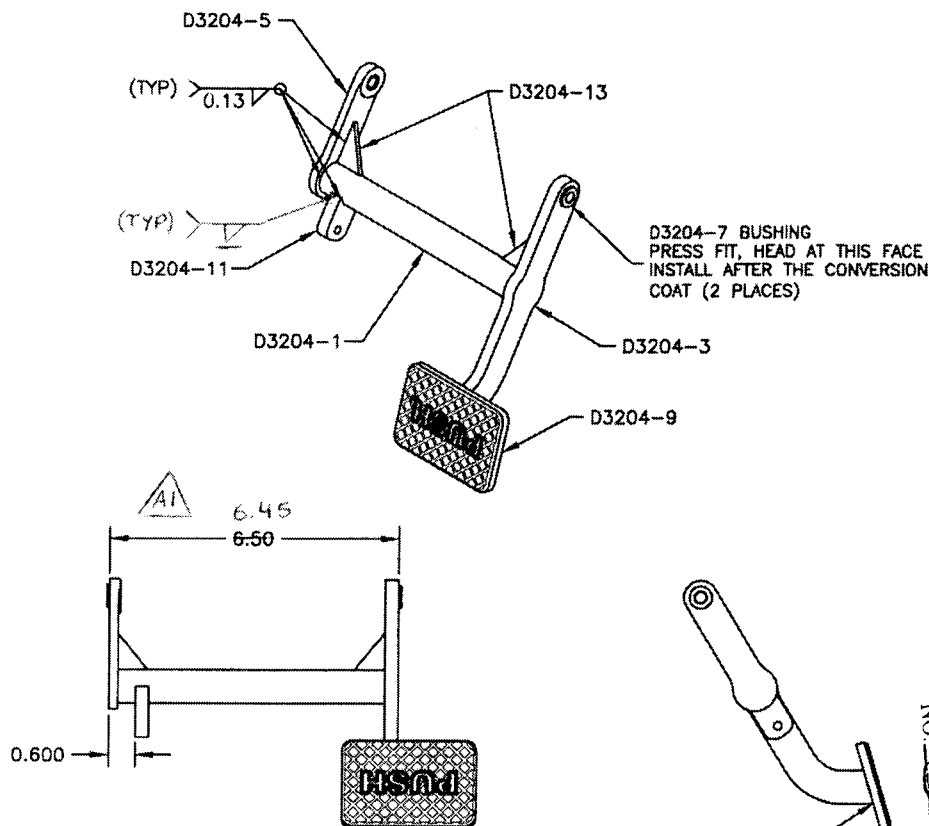
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CHECKED H	APPROVED H	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85997
12/06/19

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Dart Aerospace Ltd

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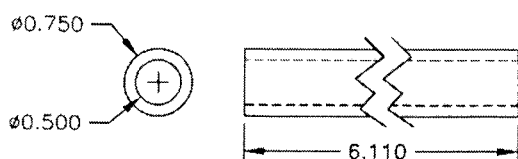
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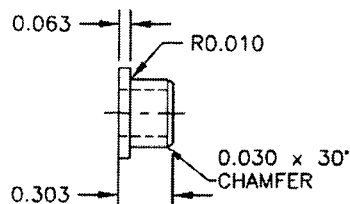


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DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

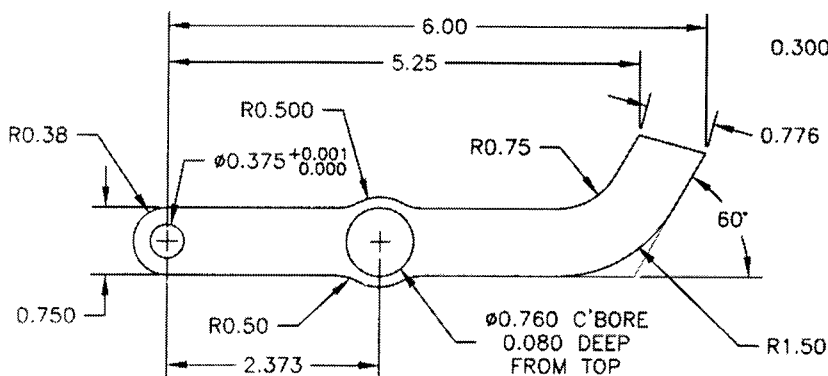
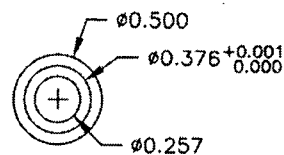
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04.04.05



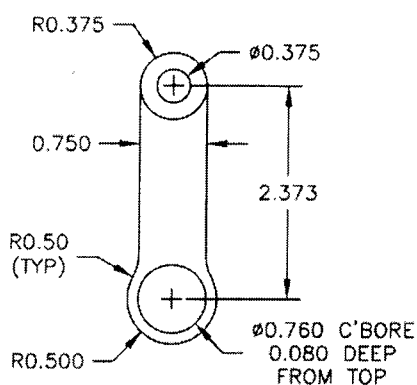
2 D3204-1 TUBE
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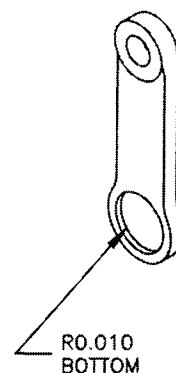
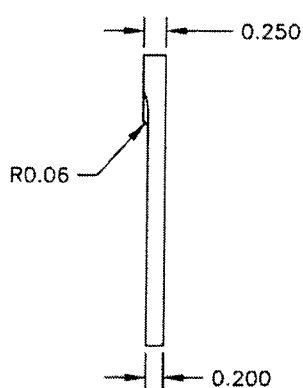
4 D3204-7 BUSHING
SCALE 1:1



3 D3204-3 ARM
SCALE 1:2



3 D3204-5 ARM
SCALE 1:2



056597

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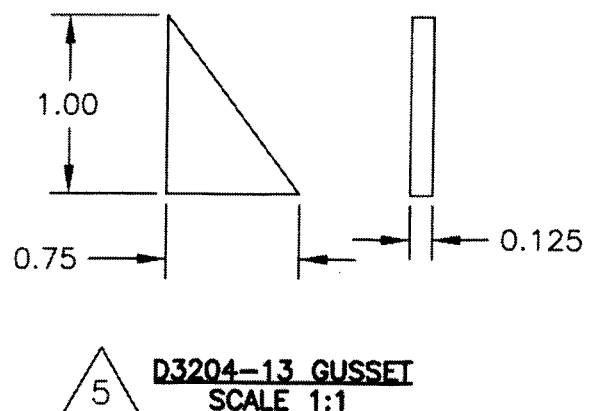
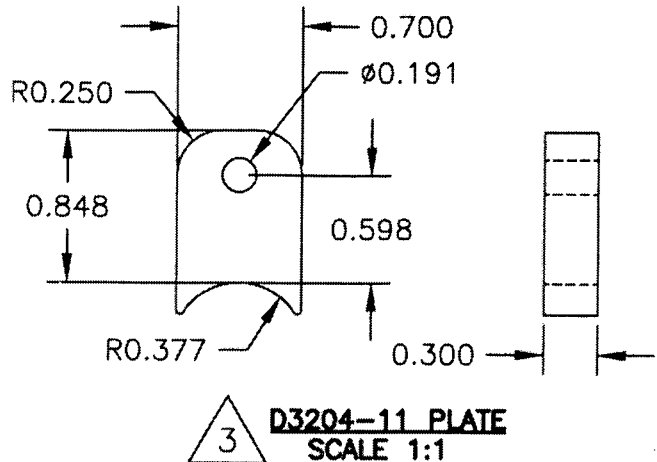
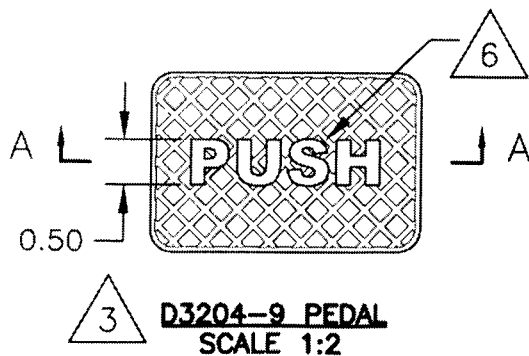
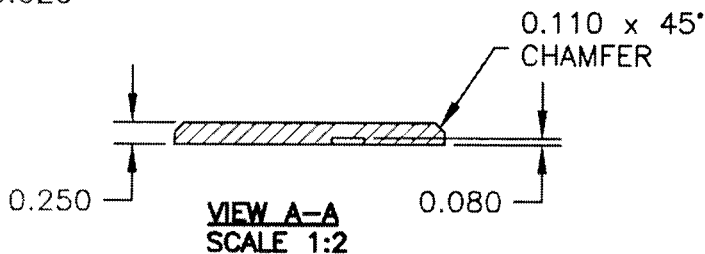
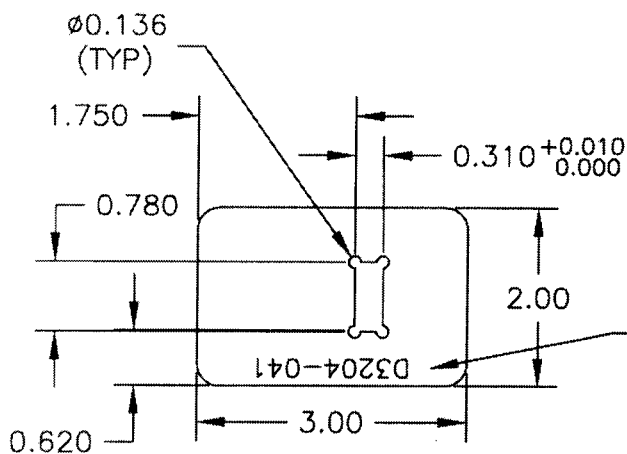
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